

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-005482**Date Inspected:** 17-Feb-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Zhi jiang/SunWei**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

On this date Caltrans Quality Assurance (QA) Inspector, Lonnie Whitehead, was present during the times noted above for observations relative to the work being performed.

LAY DOWN YARD

This QA Inspector observed the following work in progress:

F.C.A.W. repairs to the deck panel tack welds that were confirmed to be unacceptable by Phased Array Ultrasonic Testing (PAUT). Observed repair welding on weld #005 of DP489-001 (6AE). Welder is identified as #203805. ZPMC QC is identified as Sun Yan Fei. . The welding variables recorded by QC appeared to comply with the applicable WPS.

F.C.A.W. repairs to the deck panel tack welds that were confirmed to be unacceptable by Phased Array Ultrasonic Testing (PAUT). Observed repair welding on weld #004 of DP302-001 (6CE). Welder is identified as #203805. ZPMC QC is identified as Sun Yan Fei. . The welding variables recorded by QC appeared to comply with the applicable WPS.

F.C.A.W. repairs to the deck panel tack welds that were confirmed to be unacceptable by Phased Array Ultrasonic Testing (PAUT). Observed repair welding on weld #004 of DP219-001 (6AW). Welder is identified as #059443. ZPMC QC is identified as Sun Yan Fei. . The welding variables recorded by QC appeared to comply with the applicable WPS.

WELDING INSPECTION REPORT

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BAY#2

This QA inspector verified that the following deck plates and edge plates had been completed and the required non destructive testing(NDT) had been performed. Green tags were issued by American Bridge/Flour(ABF).

COMPONENT GREEN TAG

DP736A 003646

DP735A 003647

EP175B 003648

EP176B 003643

EP182A 003645

This QA Inspector performed Ultrasonic Testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated a UT report for this date. The members are identified as:

FB064-001-039

FB063-002-040

BAY#3

This QA Inspector performed Ultrasonic Testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated a UT report for this date. The members are identified as:

FB003-077-032/044

FB003-082-008/020

SSD19A-PP066-132

SSD19-PP065-137

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (15000422372), who represents the Office of Structural Materials for your project.

Inspected By:	Whitehead,Lonnie	Quality Assurance Inspector
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Reviewed By:	Clifford,William	QA Reviewer
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